

011999



Dart Aerospace Ltd.
1270 Aberdeen St
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K6A 1K7
Canada

Tel (613) 632-5200
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C3-K

Job Sheet 200766



Part No: C3-K

Job Qty: 1 pcs

Part Name: C-Series Remote Hook 3,000 lbs Lift Capacity - Keeperless



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/17/19

Job Tracking No:

Due Date: 11/4/19

Created By: Jennifer Renwick

Type: SOLD

Description: Order 19302

Note: DWG C3-K Rev 3 IPP Rev A 18.03.16 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
95	External Load - 1	1 pcs	11/4/19		0.00	1.00	External Load - 1		Michel 2019-11-20
							External Load - 2		
							External Load - 3		
100	External Load - 2 - B4B	1 pcs	11/4/19		0.00	1.00	External Load - 1 - B4B		AP 2019-11-22 Michel 2019-11-22
							External Load - 2 - B4B		
							External Load - 3 - B4B		
110	QC 5	1 pcs	11/4/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
							QC 5 - 61		
							QC 5 - 81		
130	Packaging 3-2 - Stock - B4B	1 pcs	11/4/19		0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		



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Container No: S215300



Part: C3-K

Job No: 200766

Serial No/Batch: S215300

Revision: 3

Inspector:

Exp Date:

Instructions:

Date: 09/19/19

DAS 30 9:59 NOV 22 2019

Plex 9/17/19 1:39 PM Dart.Renwick.Jennifer

				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	DAS 30 2019
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	DAS 21 2019
135 DC - 1 - B4B	1 pcs	11/4/19	0.00 0.00	DC - 1 - B4B	DAS 21 2019
				DC - 2 - B4B	
140 QC 21 - SA	1 pcs	11/4/19	0.00 0.00	QC 21 - SA - 21	DAS 21 2019
				QC 21 - SA - 70	
				QC 21 - SA - 53	

Part Op 95 - Issue S/N

Descriptions: 100 - (Small Fab)1- PICK C3-2-1 AND LASER ENGRAVE AS PER DWG . SEE NOTE 3 AND 4 ON SHEET 2. 2- ASSEMBLE AS PER DWG

110 - (QC5- Inspect part completeness to step on W/O)

130 - (Identify as per dwg & Stock Location: _____)Identify and Stock

135 - (Document Control)Photocopy blue file OM & OOPM-C3 Rev 4

140 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
188-FPSS-1032-1/4	Set Screw	2 Ea (2 ea)	95-External Load - 1	5110 495
188-FSCS-832-5/8	Clock Spring Cover Screw	4 Ea (4 ea)	100-External Load - 2 - B4B	5126 989
2595K22	Heat Shrink Tube	1 pcs (1 ea)	100-External Load - 2 - B4B	5073 047
32446	Crimp Terminal	2 Ea (2 ea)	100-External Load - 2 - B4B	5074 909
8183K6 P	Wire Guide/Grip	1 Ea (1 ea)	100-External Load - 2 - B4B	5029 491
AN4-16A	Bolt	3 Ea (3 ea)	100-External Load - 2 - B4B	5196 064-2

AN4-17A	Bolt	1 Ea (1 ea)	100-External Load - 2 - B4B
AN6-15A	Bolt	1 Ea (1 ea)	100-External Load - 2 - B4B
C2-1-1	Manual Release Knob	1 pcs (1 ea)	100-External Load - 2 - B4B
C2-10-1	Lock Spring Pin	1 pcs (1 ea)	100-External Load - 2 - B4B
C2-11-2	Locating Pin	2 Ea (2 ea)	100-External Load - 2 - B4B
C2-3-1	Latch Shaft Du Bearing	2 pcs (2 ea)	100-External Load - 2 - B4B
C2-3-10	Latch Shaft	1 pcs (1 ea)	100-External Load - 2 - B4B
C2-3-11	Actuator	1 pcs (1 ea)	100-External Load - 2 - B4B
C2-3-2	Latch Roller Pin	1 pcs (1 ea)	100-External Load - 2 - B4B
C2-3-2-1	Roller Pin Retaining Ring	2 Ea (2 ea)	100-External Load - 2 - B4B
C2-3-3	Latch Roller	1 pcs (1 ea)	100-External Load - 2 - B4B
C2-3-3-1	Latch Roller DU Bearing	1 pcs (1 ea)	100-External Load - 2 - B4B
C2-3-5	Spacer, Teflon	2 Ea (2 ea)	100-External Load - 2 - B4B
C2-3-6	Latch	1 pcs (1 ea)	100-External Load - 2 - B4B
C2-3-8	Actuator Shaft Bushing	2 pcs (2 ea)	100-External Load - 2 - B4B
C2-5-1	Actuator Stop	1 Ea (1 ea)	100-External Load - 2 - B4B
C3-10-2	Lock Spring	1 pcs (1 ea)	100-External Load - 2 - B4B
C3-11-1	Side Plate - Solenoid C3-Hook	1 pcs (1 ea)	100-External Load - 2 - B4B
C3-12-1	Lock Bushing	2 pcs (2 ea)	100-External Load - 2 - B4B
C3-12-2	Lock Shaft - C3 Hook	1 pcs (1 ea)	100-External Load - 2 - B4B
C3-12-3	Lock - C3 Hook	1 pcs (1 ea)	100-External Load - 2 - B4B
C3-12-4 Po	Lock Roller	1 pcs (1 ea)	100-External Load - 2 - B4B
C3-12-5	Lock Roller Pin	1 pcs (1 ea)	100-External Load - 2 - B4B
C3-12-6	Lock Roller Pin Circlip	2 Ea (2 ea)	100-External Load - 2 - B4B
C3-13-1	Keeper Bushing	2 pcs (2 ea)	100-External Load - 2 - B4B
C3-13-4-2	Keeperless Adapter	1 pcs (1 ea)	100-External Load - 2 - B4B
C3-2-1	Side Plate C-3 Hook	1 pcs (1 ea)	100-External Load - 2 - B4B
C3-3-4	Link Pin	2 pcs (2 ea)	100-External Load - 2 - B4B
C3-3-4-1	Ring, Retalning	4 pcs (4 ea)	100-External Load - 2 - B4B
C3-3-7	Link	1 pcs (1 ea)	100-External Load - 2 - B4B
C3-3-9	Actuator Spring	1 pcs (1 ea)	100-External Load - 2 - B4B
C3-4-1	Load Beam Bushing	2 pcs (2 ea)	100-External Load - 2 - B4B
C3-4-4KA	Keeperless Load Beam Assembly - C3 Hook	1 pcs (1 ea)	100-External Load - 2 - B4B
C3-7-1	Load Beam Bumper	1 pcs (1 ea)	100-External Load - 2 - B4B
C3-7-2	Lock Bumper	2 pcs (2 ea)	100-External Load - 2 - B4B
C3-8-2	Solenoid	1 pcs (1 ea)	100-External Load - 2 - B4B
C3-8-4	Solenoid Cover Gasket	1 pcs (1 ea)	100-External Load - 2 - B4B
C3-8-5	Solenoid Cover	1 pcs (1 ea)	100-External Load - 2 - B4B
C3-9-1	Clock Spring Cover - C3 Hook	1 pcs (1 ea)	100-External Load - 2 - B4B
C3-9-2	Spring, Clock	1 pcs (1 ea)	100-External Load - 2 - B4B
EL-PLUG-M	3-Prong Male Spade Plug	1 Ea (1 ea)	100-External Load - 2 - B4B
M27500-16TG2T14	Wire - 16-Gauge - Shielded	1 ft (1 ea)	100-External Load - 2 - B4B
MS21044N4	Nut, Self-Locking	4 Ea (4 ea)	100-External Load - 2 - B4B
MS21083-N3	Nut	2 Ea (2 ea)	100-External Load - 2 - B4B
MS21083N6	Nut	1 Ea (1 ea)	100-External Load - 2 - B4B
MS35266-63	Solenoid Cover Screw	1 Ea (1 ea)	100-External Load - 2 - B4B
NAS1149F0332P	Washer (AN960-10L)	2 Ea (2 ea)	100-External Load - 2 - B4B
NAS1149F0363P	Washer (AN960-10)	1 Ea (1 ea)	100-External Load - 2 - B4B
NAS1149F0463P	Washer (AN960-416)	8 Ea (8 ea)	100-External Load - 2 - B4B
NAS1149F0632P	Washer (AN960-616L)	2 Ea (2 ea)	100-External Load - 2 - B4B

5157429-3
 5068641
 5190045
 5068051
 5061528
 5177832
 5180418
 5174393
 5173563
 5168878
 5116487
 5182513
 5199313
 5148221
 5196195
 5072964
 5197483
 5182333
 5193685
 5080193
 5190711
 5125633
 5188182
 5206297
 5206235
 5175253
 5175253
 5218778
 5214930
 5048390
 5128955
 5192917
 5059062
 5208794
 5214422
 5210104
 5213024
 5204110
 5116295
 5089524
 5192574
 5045144
 5203176
 5142051
 5192157
 5183289
 5103666
 5075330-3
 5201001
 5137711
 5048297

5230390
 5112143

Loctite 242 (5186572)
 Loctite 620 (5194792)
 Self-T-ze (M138973)
 Aeroshell grease NO.7 (M138724)

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
95-External Load - 1	188-FPSS-1032-1/4	2	101	0
100-External Load - 2 - B4B	188-FSCS-832-5/8	4	197	0
	2595K22	1	26	0
	32446	2	596	0
	8183K6	1	22	0
	AN4-16A	3	352	0
	AN4-17A	1	253	0
	AN6-15A	1	32	0
	C2-1-1	1	9	0
	C2-10-1	1	65	0
	C2-11-2	2	38	0
	C2-3-1	2	64	0
	C2-3-10	1	11	0
	C2-3-11	1	19	0
	C2-3-2	1	22	0
	C2-3-2-1	2	28	0
	C2-3-3	1	43	0
	C2-3-3-1	1	26	0
	C2-3-5	2	101	0
	C2-3-6	1	3	0
	C2-3-8	2	49	0
	C2-5-1	1	3	0
	C3-10-2	1	26	0
	C3-11-1	1	11	0
	C3-12-1	2	40	0
	C3-12-2	1	17	0
	C3-12-3	1	21	0
	C3-12-4	1	28	0
	C3-12-5	1	30	0
	C3-12-6	2	102	0
	C3-13-1	2	66	0
	C3-13-4-2	1	10	0
	C3-2-1	1	13	0
	C3-3-4	2	2	0
	C3-3-4-1	4	118	0
	C3-3-7	1	12	0
	C3-3-9	1	31	0
	C3-4-1	2	39	0
	C3-4-4KA	1	8	0
	C3-7-1	1	36	0
	C3-7-2	2	24	0
	C3-8-2	1	17	0
	C3-8-4	1	53	0
	C3-8-5	1	21	0
	C3-9-1	1	12	0
	C3-9-2	1	30	0
	EL-PLUG-M	1	14	0
	M27500-16TG2T14	1	40	0
	MS21044N4	4	69	0
	MS21083-N3	2	44	0
	MS21083N6	1	48	0
	MS35266-63	1	22	0
	NAS1149F0332P	2	1,756	0
	NAS1149F0363P	1	352	0
	NAS1149F0463P	8	496	0
	NAS1149F0632P	2	312	0

Part Specifications

Specifications could not be found.

Plex 9/17/19 1:39 PM Dart.Renwick.Jennifer

MAKE SURE YOU ARE USING THE CORRECT TEST FORM FOR THE CORRECT SOLENOID!

NEW SOLENOID (152951-001)

Work Order 200766

Customer Order 19302

Serial Number 5215300

Date 2019-11-22

# of Releases	Load (Lbs.)	Release Method	Remarks	Result	Pass/Fail
1	7,500	Static Hold	Hold for two minutes and reduce load to zero	N/A	<u>Pass</u>
10	1,500	Electrical, 25 volts	No "hang ups" permitted	N/A	<u>Pass</u>
2	3,000	Electrical, 22 volts	Current shall not exceed 12.8 A	<u>9.9</u> A	<u>Pass</u>
2	2,500	Electrical, 22 volts	Current shall not exceed 12.8 A	<u>9.8</u> A	<u>Pass</u>
2	2,000	Electrical, 22 volts	Current shall not exceed 12.8 A	<u>9.8</u> A	<u>Pass</u>
2	1,500	Electrical, 22 volts	Current shall not exceed 12.8 A	<u>9.8</u> A	<u>Pass</u>
2	500	Electrical, 22 volts	Current shall not exceed 12.8 A	<u>9.7</u> A	<u>Pass</u>
1	3,000	Electrical, 20 volts	Current shall not exceed 11.6 A	<u>8.8</u> A	<u>Pass</u>
1	3,000	Electrical, 28 volts	Current shall not exceed 16.2 A	<u>12.3</u> A	<u>Pass</u>
1	3,000	Manual		N/A	<u>Pass</u>
1	3,000	Impact Test	Impact shackle 10x, shall not release	N/A	<u>Pass</u>
1	N/A	Solenoid Ohms	Shall not exceed 1.7-2.0 Ω	<u>1.8</u> Ω	<u>Pass</u>
1	N/A	Electrical Continuity	Across both wires	N/A	<u>Pass</u>

Test Conducted By: Michel Lalonde
Technician

Signature: Sylvie Pouchet
QC 5 Small FAB / QA

Submit